

Work Order ID: 82391

82391

Page 1

March-30-12 7:47:37 AM

Item ID: D3637-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 29/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/30

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3637

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3637 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

2024 .050

(12)

MLJ
12-4-11

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

(12)

MLJ
12-4-11

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sub

(12)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 82391

March-30-12 7:47:37 AM

82391

Page 2

Item ID: D3637-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 29/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

130

Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Form as per Dwg D3637

(12)

S
rlos/22

140

140

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

S rlos/22

(12)

150

150

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-drill holes as per dwg using DT89792- c'sink holes as per dwg3-deburr

(12)

FF
12-06-06

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

82391

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 29/03/2012 **Start Qty:** 12.00

12

Cust Item ID:**Required Date:** 12/04/2012 **Req'd Qty:** 12.00

12

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

| Tool ID | Tool # | Plan Code |
|---------|--------|-----------|
|---------|--------|-----------|

| Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|------------|------------|---------------|-------------|
| | | | |

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 82391

March-30-12 7:47:37 AM

82391

Page 4

Item ID: D3637-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 29/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location **245A**

0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

122**12/6/11****12/6/11****MF**
12-06-08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March-30-12 7:47:41 AM

Page 1

Work Order ID: 82391

82391

Parent Item: D3637-3

D3637-3

Parent Item Name: Bracket

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M2024T3S.050 | | Purchased | No | | | 100 | sf | 120.9000 | 0.134 | 1.692632 | | | |

M2024T3S 050

2024-T3 .050 sheet

**

Location

Loc Qty

Loc Code

MAT022

120.9

117684

24.9

121216

96

121216

12

SM
12-4-11

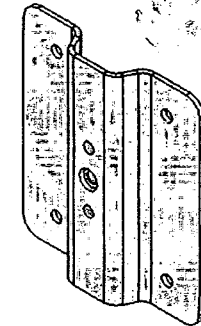
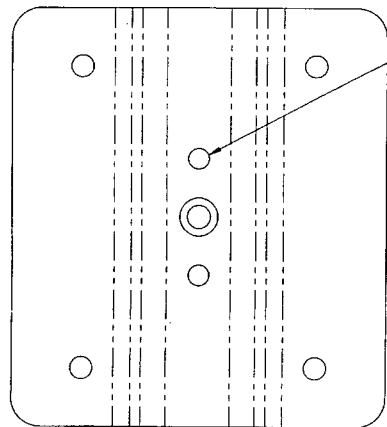
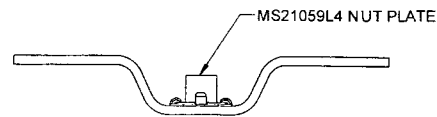
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

| QTY | P/N | DESCRIPTION |
|-----|--------------|------------------|
| X | D3637-041 | BRACKET ASSEMBLY |
| 1 | D3637-1 | BRACKET |
| 1 | MS21059L4 | NUTPLATE |
| 2 | MS20426AD3-3 | RIVET |

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

82391 MLJ
12/03/30

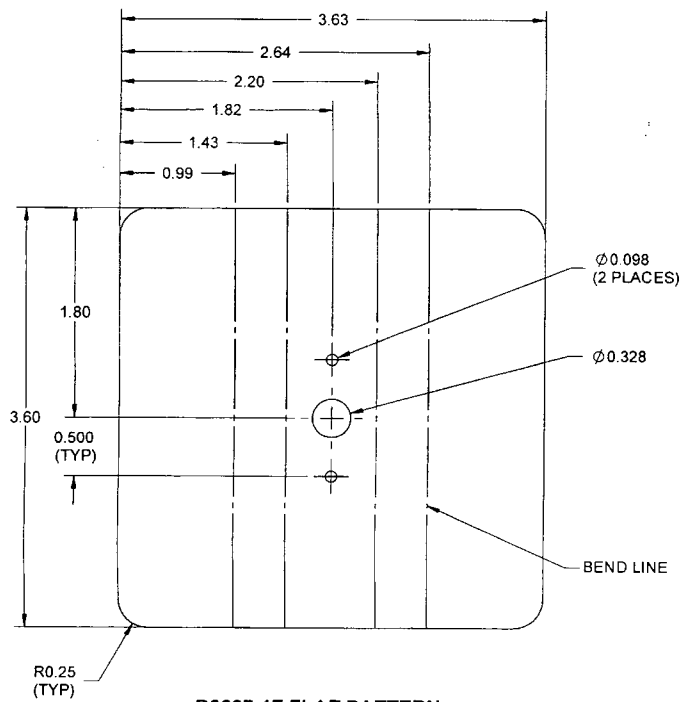
| B | FOR D3637-1, 1 15 WAS 1 30 & "REF" REMOVED FROM ANGLE | LE | 07.12.18 |
|------------|---|----|----------|
| A | NEW ISSUE: REPLACES G10608, G10602 & G10609 | LE | 07.07.27 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JS | | |
| DRAWN | JS | | |
| CHECKED | JS | | |
| MFG. APPR. | JS | | |
| APPROVED | JS | | |
| DE APPR. | JS | | |
| DATE | 07.12.18 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

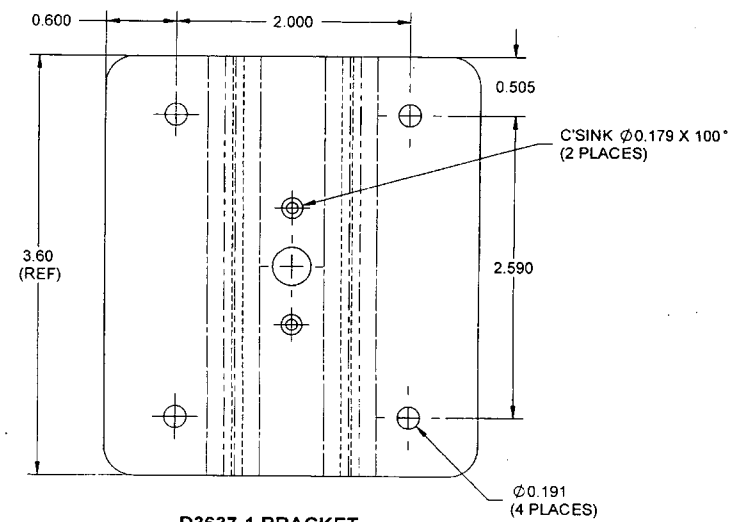
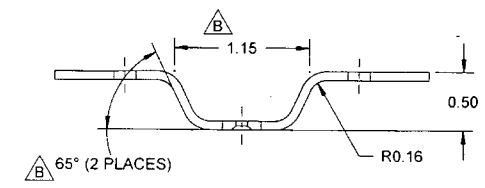
DRAWING NO. D3637
TITLE BRACKET
REV. B
SHEET 1 OF 3
SCALE 1:1

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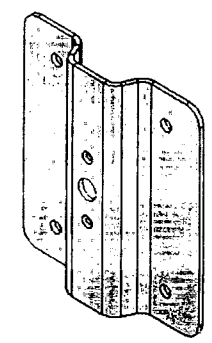
82391



D3637-1F FLAT PATTERN

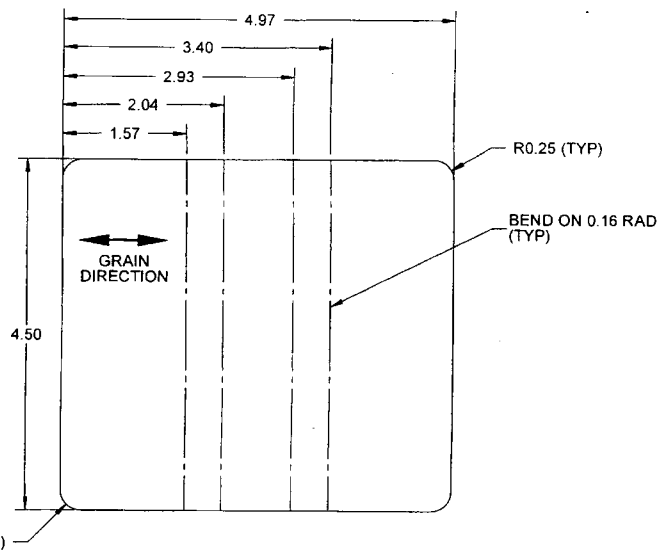


**D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)**

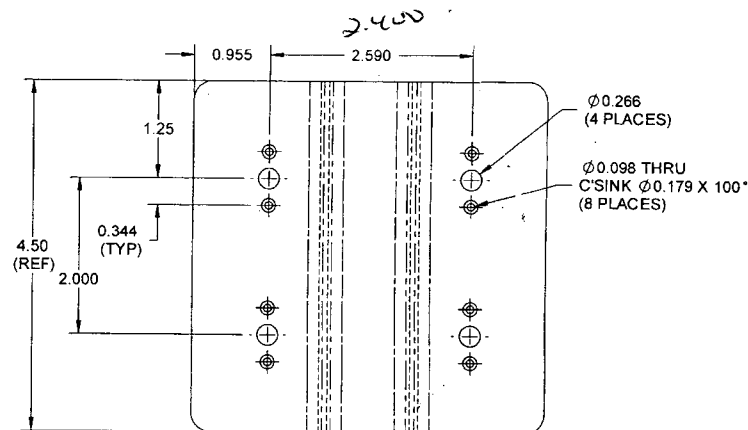
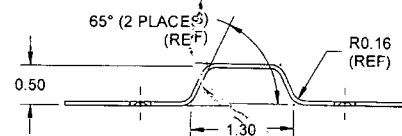


- D3637-1 NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.26 lbs

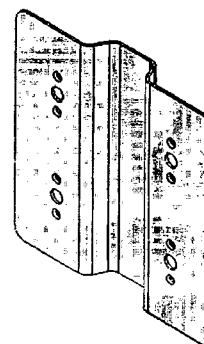
| | | | |
|--|----------|--|--------------|
| DESIGN | TS | DART AEROSPACE LTD | |
| DRAWN | LE | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ME | DRAWING NO. | REV. B |
| MFG. APPR. | CS | D3637 | SHEET 2 OF 3 |
| APPROVED | JS | TITLE | SCALE |
| DE APPR. | JS | BRACKET | 1:1 |
| DATE | 07.12.18 | COPYRIGHT © 2007 BY DART AEROSPACE LTD | |
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D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

| | | | |
|--|----------|--|--------------|
| DESIGN | TS | DART AEROSPACE LTD | |
| DRAWN | LE | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PH | DRAWING NO. | REV. B |
| MFG. APPR. | ED | D3637 | SHEET 3 OF 3 |
| APPROVED | N | TITLE | SCALE |
| DE APPR. | ST | BRACKET | 2:3 |
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02390
2.590
955
1.545
3.955
4.500

37

A